

## Process Sheet

Split up  
8/07/08 7/25

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORTING PLATE		
Job Number	: 40734			Part Number	: D37811		
Estimate Number	: 13298			Drawing Number	: D3781 PRELIM 08.07.08		
P.O. Number	:			Project Number	: N/A		
This Issue	: 23/07/2008	S.O. No.	:	Drawing Revision	: PRELIM		
Prsht Rev.	: NC			Material	:		
First Issue	: / /			Due Date	: 30/07/2008		
Previous Run	: 39036			Qty:	3 Um: Each		
Written By							
Checked & Approved By							
Comment	: Est Rev:A 08-05-01 new issue DD verified by:EC						
	: Est Rev:B 08-07-22 revB as per dwg DD verified by:EC						

Additional Product

**PRELIMINARY ISSUE**

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M0001T6S000 M2024T35080	6061-T6 .080 Sheet 08.07.24
Comment: Qty.: 0.2896 sf(s)/Unit Total : 2.8959 sf(s) 6061-T6 .080 Sheet batch: 07460 HB 8-7-23		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3781-1 Dwg Rev: PRE L. HB 8-7-24 Prog Rev: PRE L. ****grain direction along 3.61" **** 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE HB 8-7-24		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK S 08/07/24 2/4		
5.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Bend as per Dwg D3781 HB 08/07/25 3		

**БЪДЕНИЯ ISSUE**

## Process Sheet

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Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-counter sink holes as per dwg D3781

*23/07/28 ③*

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

*S 08/07/28 X3*

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*QVBL 08/07/28 X3*

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Fix 08/07/28 ③*

10.0	MS20426AD34	RIVET
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 100.0000 Each(s)

RIVET

batch: *105978*

*SP*

11.0	MS21075L3	Nutplate
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 50.0000 Each(s)

Nutplate

batch: *M108757*

*8/07/29 SP*

12.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble nut plate as per dwg D3781

*23/07/29 ③*

13.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**

*200.07.29 S 08/07/29 X3*

**VALVOLINE  
ENDURANCE**

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORTING PLATE

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Job Number:



Seq. #:	Machine Or Operation:	Description :
14.0	PACKAGING 1	PACKAGING RESOURCE #1  Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Stores 119 Hand/Chart 12 sent to 1 After key shlang ax sd
15.0	QC21	FINAL INSPECTION/W/O RELEASE  Comment: FINAL INSPECTION/W/O RELEASE

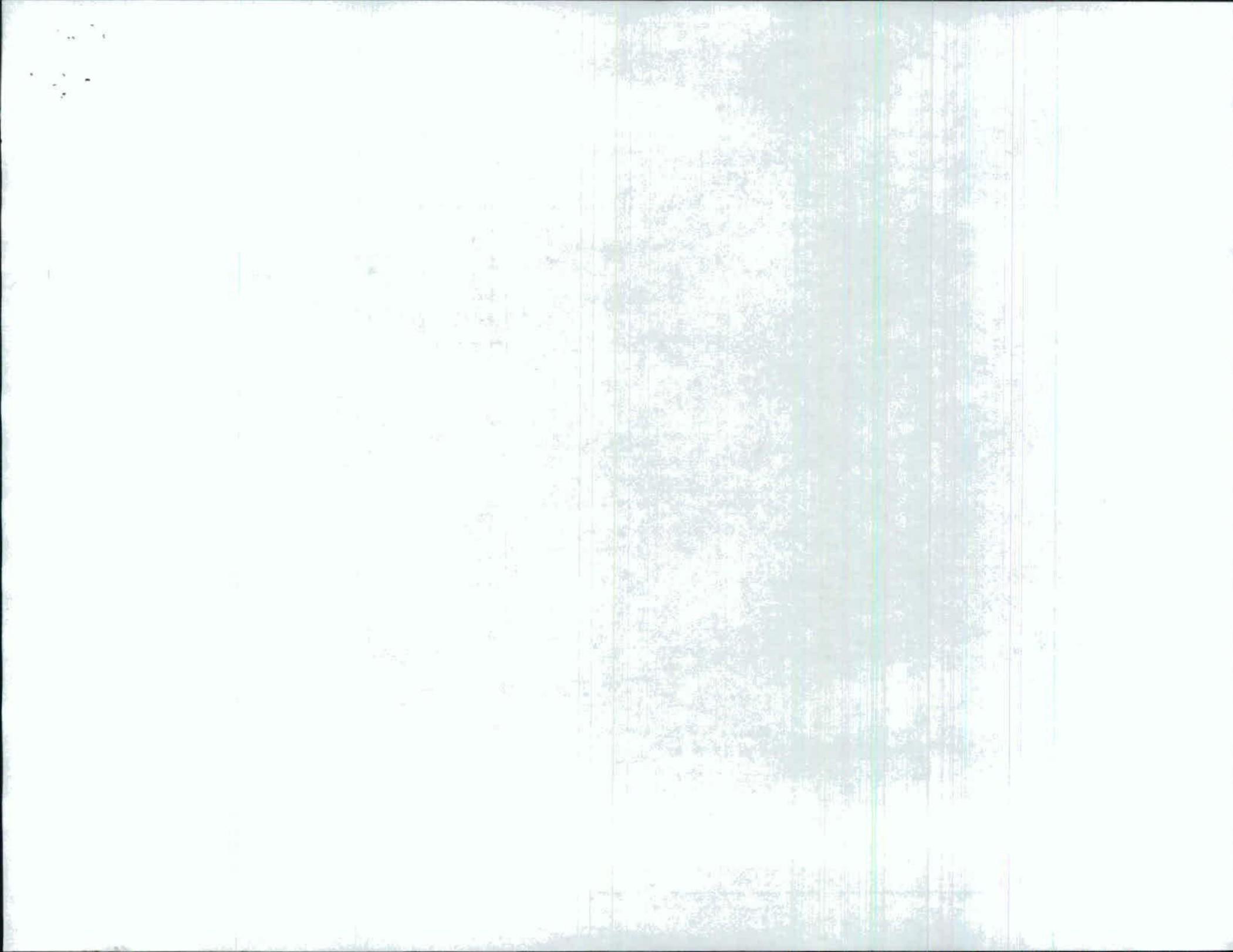
Job Completion



MF 08-07-29

## POSITIVE RECALL

EFFECTIVE 08.07.13 AUTH LH  
 RELEASED 09.02.17 DATE 09.02.17  
 EFFF  
 RELC

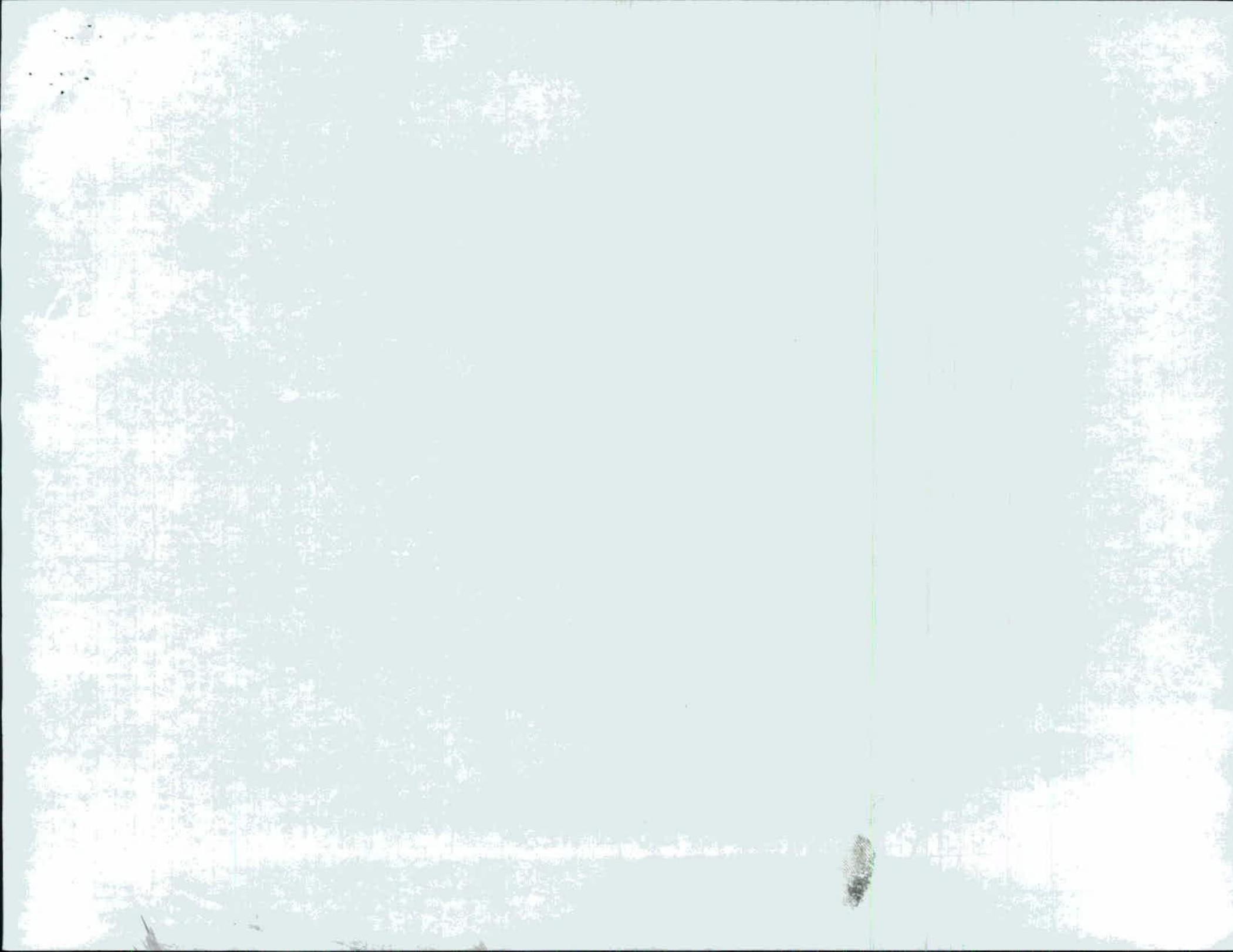


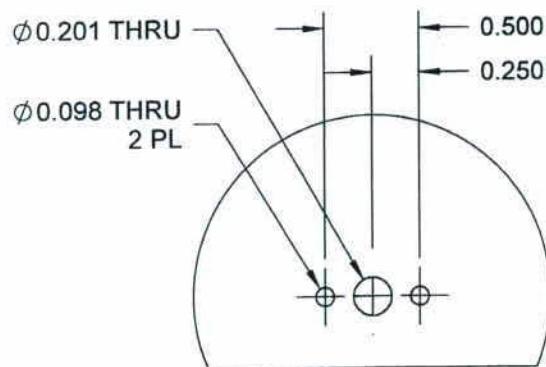
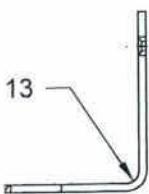
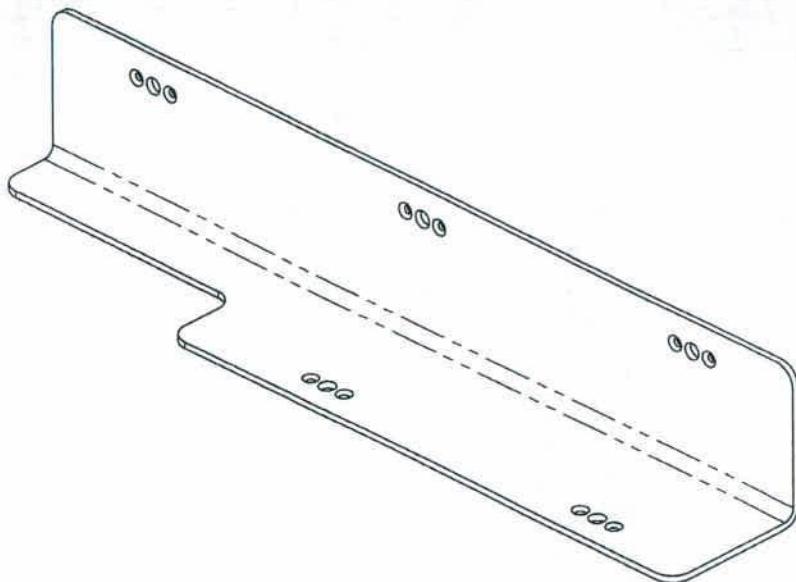
ART AEROSPACE LTD	Work Order:	40734
Description: SUPPORTING PLATE	Part Number:	D3781-1
Inspection Dwg:D3781 Rev: PRELIM		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Measured by:	HB	Audited by:	C	Prototype Approval:	<input checked="" type="checkbox"/>
Date:	8-7-24	Date:	08/07/24	Date:	<del>✓</del> 08.07.24
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	





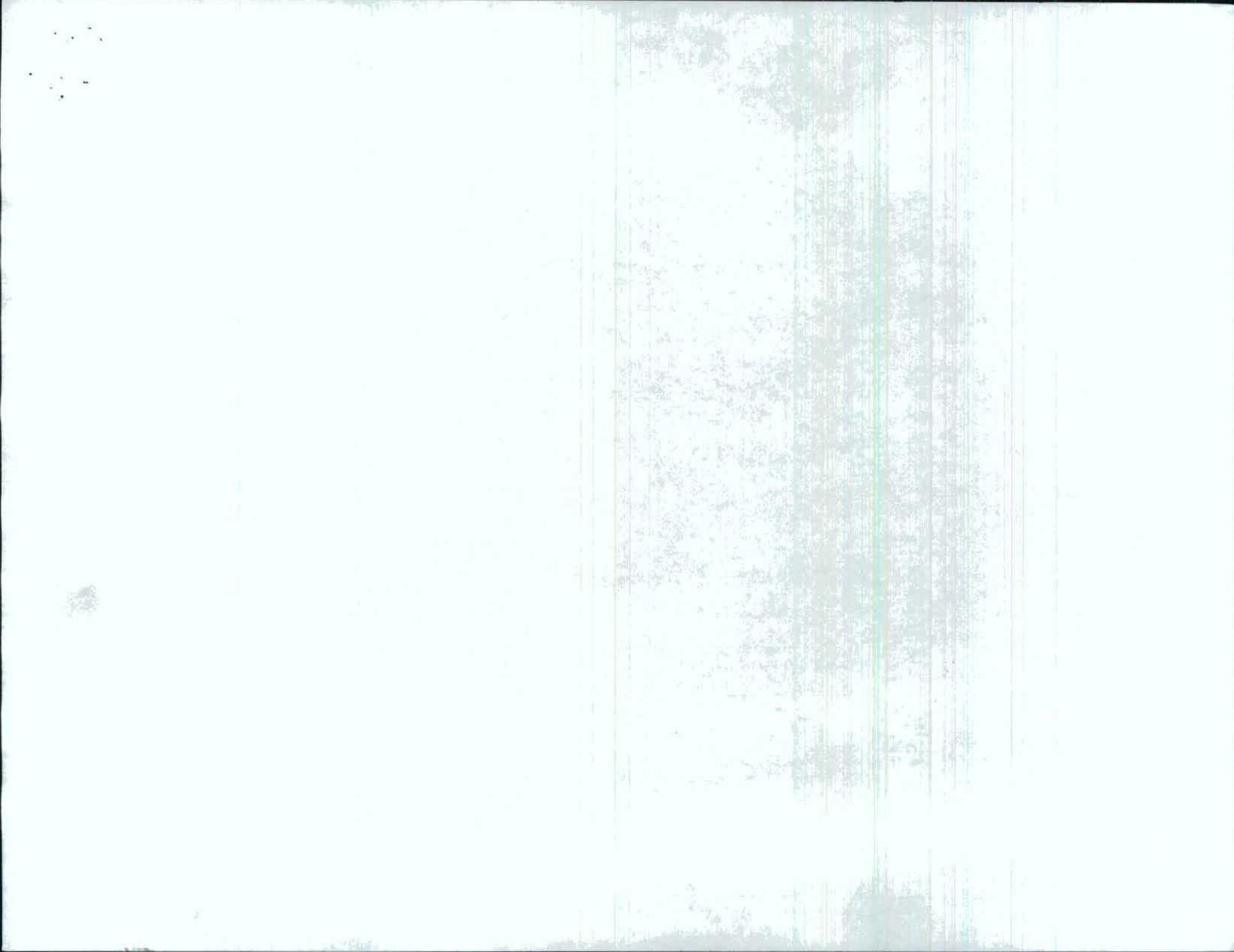
407347

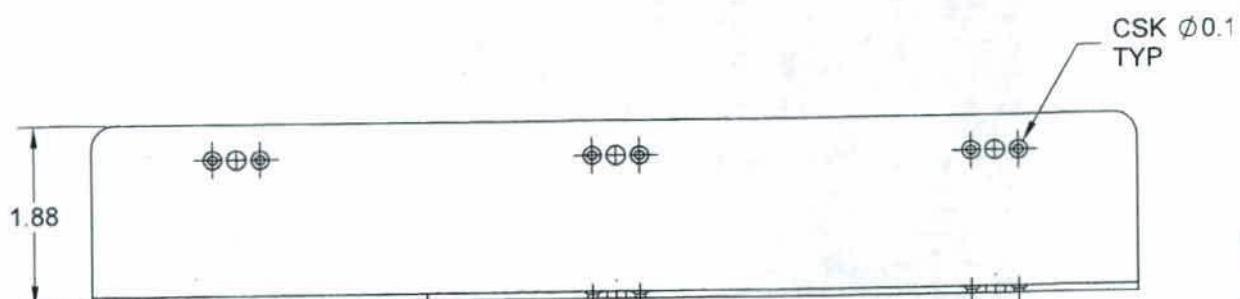
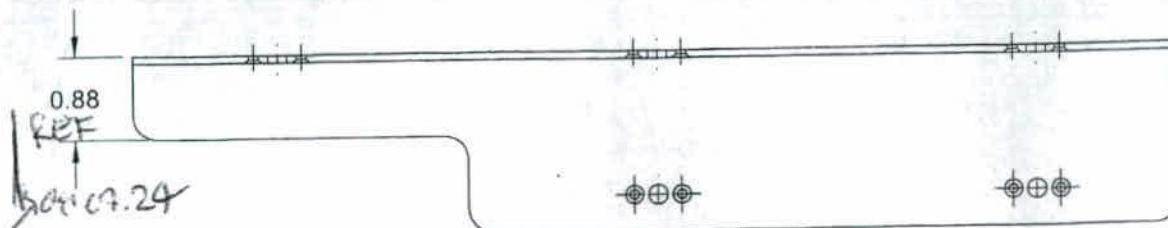
**DETAIL B**  
SCALE 2X, 5 PL

**PRELIMINARY ISSUE**

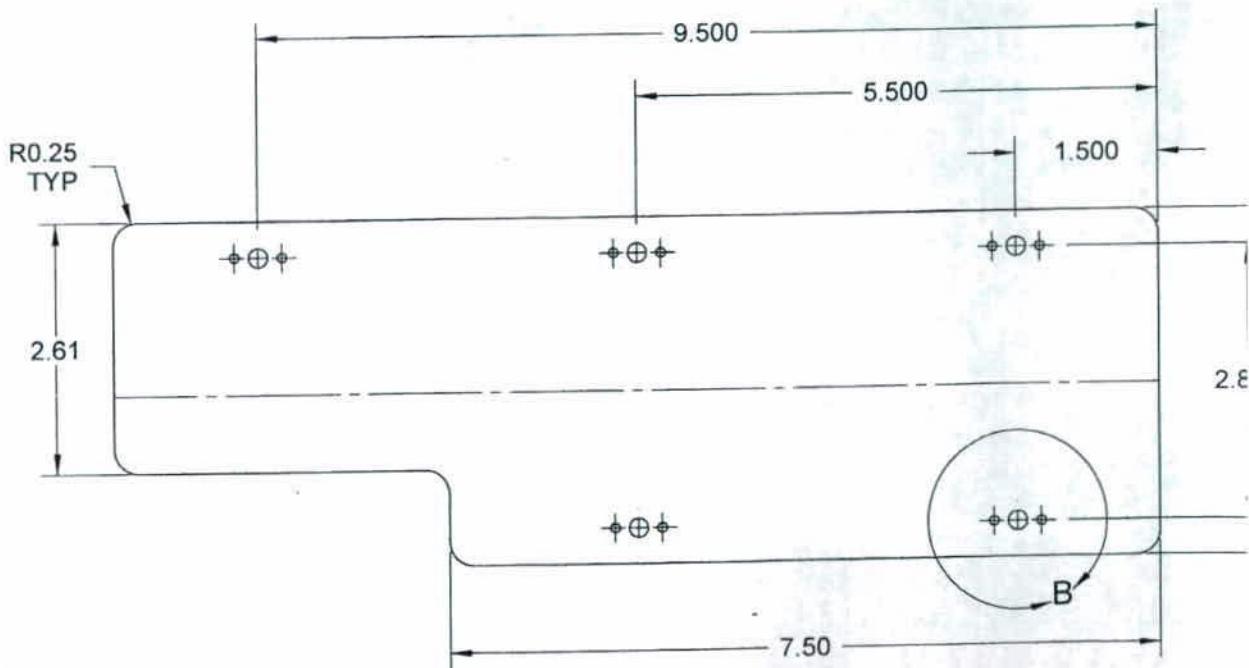
08.07.16

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3781	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	08.07.15	COPRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





**D3781-1 SUPPORTING PLATE**  
MAKE FROM D3781-1F

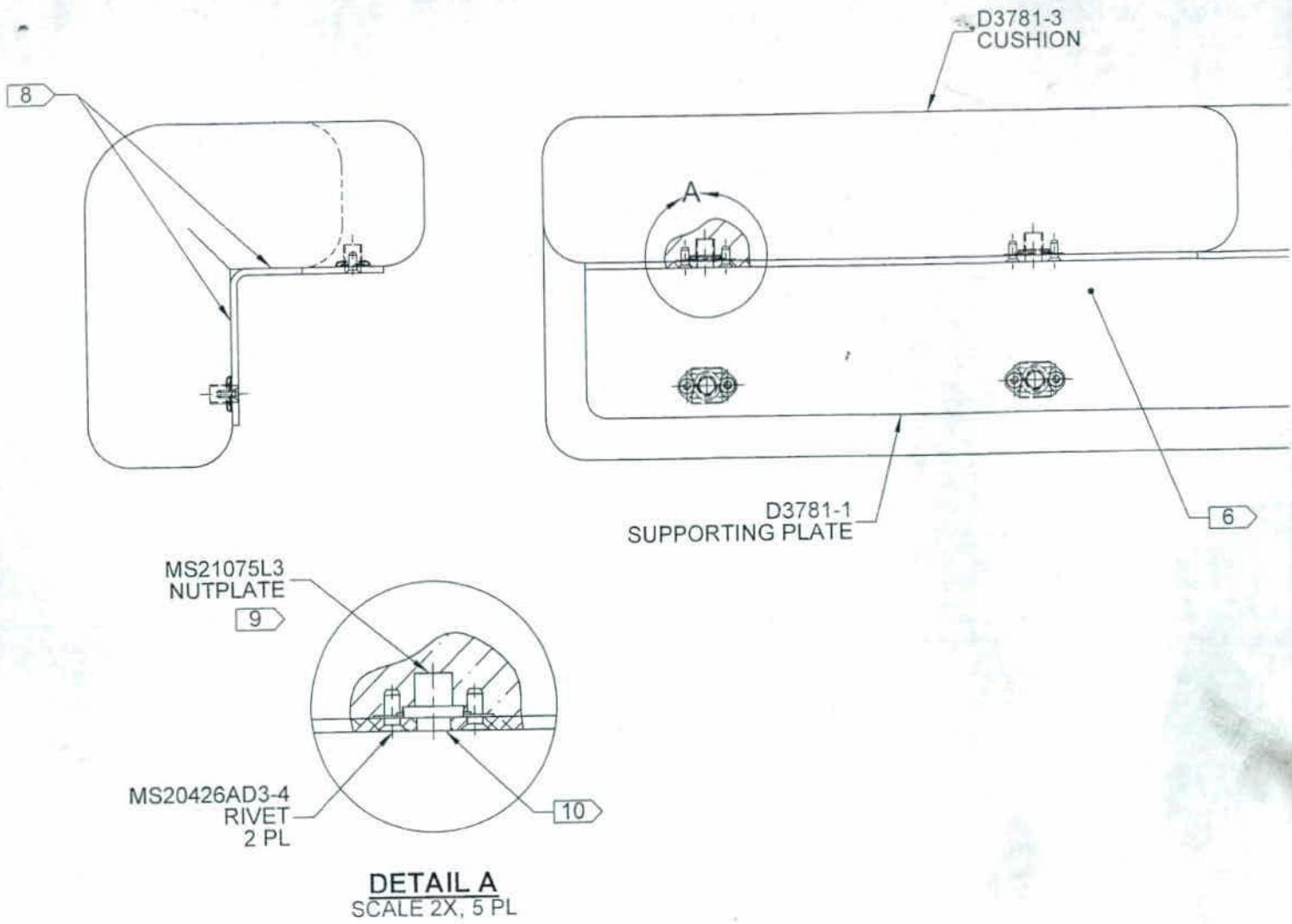


**D3781-1F FLAT PATTERN**

**D3781-1 NOTES:**

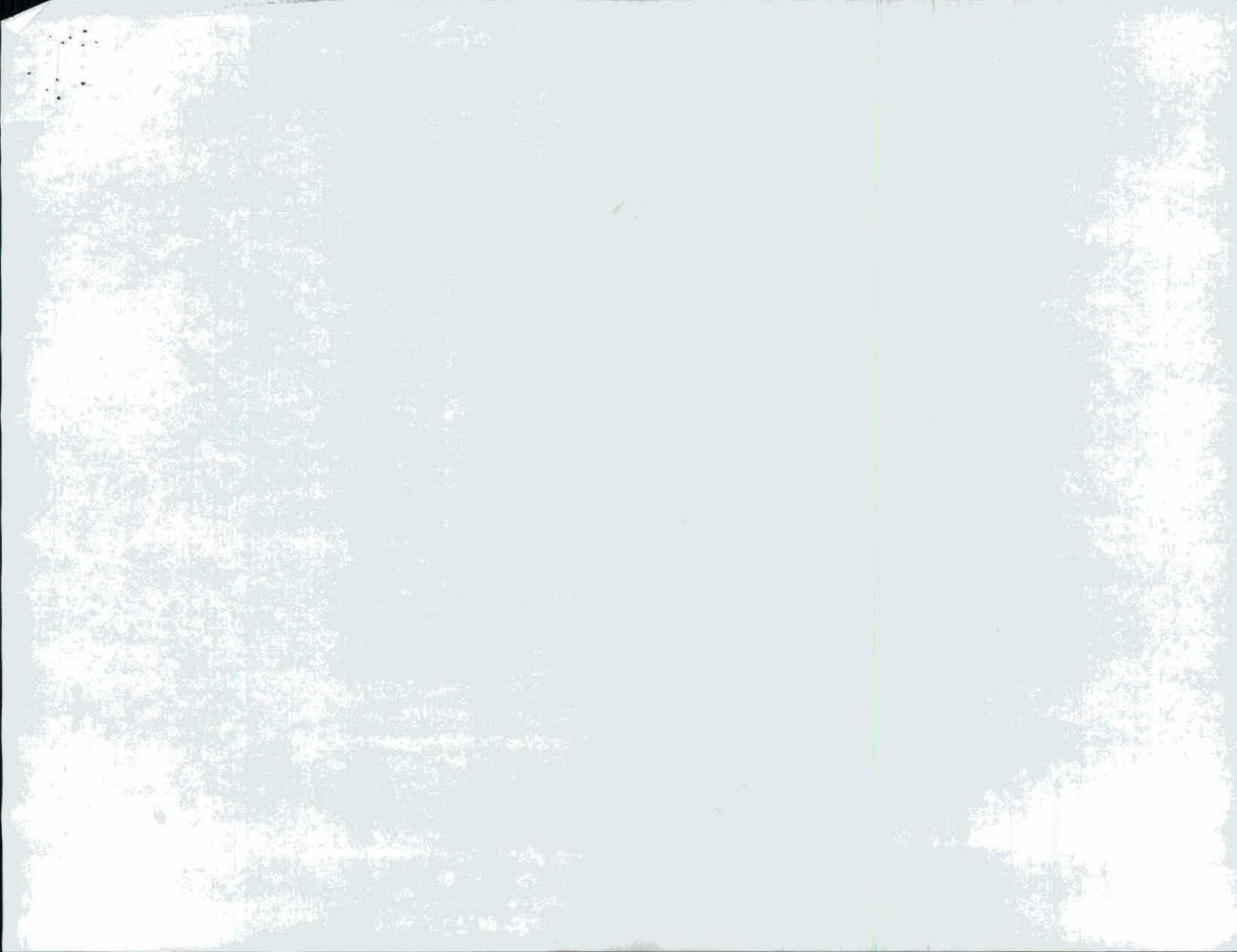
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs

W0  
4025



**D3781-041 NOTES:**

- 1) MATERIAL: COVER D3781-1-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111. BOND FABRIC USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS. THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.00 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CENTERING ON THE D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC



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8/08/07/25

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P.O. Number	:		Part Number	: D37811	
This Issue	: 23/07/2008	S.O. No. :	Drawing Number	: D3781 PRELIM	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: //		Drawing Revision	: PRELIM	
Previous Run	: 39036		Material	:	
Written By	:		Due Date	: 30/07/2008	
Checked & Approved By	:		Qty:	3	
Comment	:		Um:	Each	
Additional Product					

## PRELIMINARY ISSUE



Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M6061-T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2896 sf(s)/Unit Total : 2.8959 sf(s)

6061-T6 .080 Sheet

batch: 107460

IR 8-7-23 PD 5859



2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3781-1

Dwg Rev: PRE L

Prog Rev: PRE L

IR 8-7-24

(14)

\*\*\*\*grain direction along 3.61" \*\*\*\*

2- Debur if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IR 8-7-24

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/07/24 814

5.0 BRAKE NC NC BRAKE

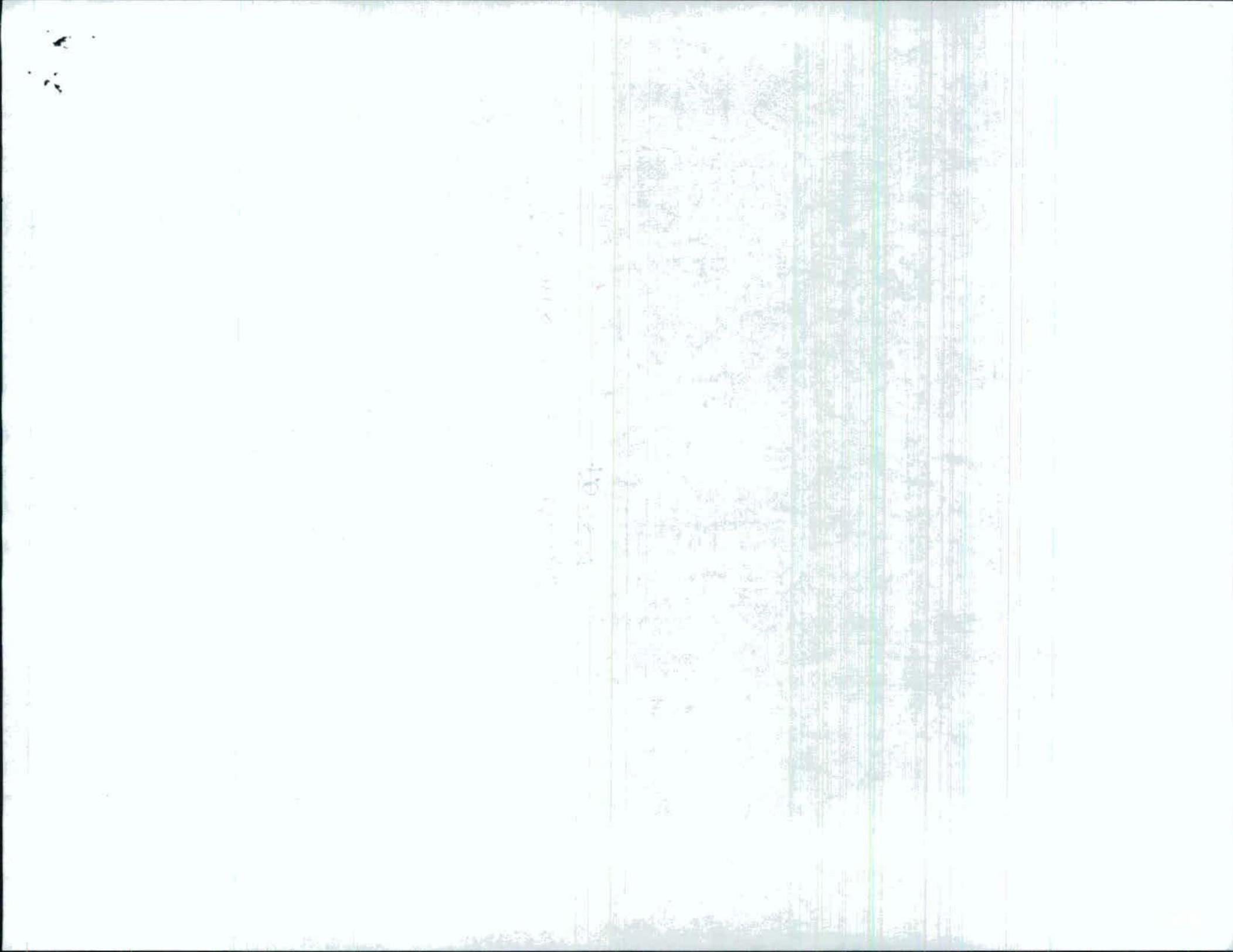


Comment: NC BRAKE

Bend as per Dwg D3781

IR 08/07/25

(3)







SHIP TO:

# KAISER

## ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2585

SOLD TO:

**CERTIFIED TEST REPORT**

Serial Number

4073190

CUSTOMER PO NUMBER:		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP UNLOAD ID:		GOVT CONTRACT NUMBER:	
N18592						100769/6			
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:	PRODUCT DESCRIPTION:			
1038947	6	10-AUG-2006	2024	BARE	T3	KAISER STRETCH			
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:	Gauge		WIDTH:	LENGTH:			
4317 LB	76 PCS EST.	209286	0.0800 IN		48.000 IN	144.000 IN			

**Certified Specifications**

AMS 4037/RevN

AMS-OO-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

**Test Results**

Lot: 368375A2 Cast 340

Drop 33

Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	68.7 : 67.1 (460 : 463)	45.6 : 45.6 (314 : 314)	19.0 : 19.6

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.23	4.53	0.60	1.37	0.01	0.17	0.02	0.01	0.01	TOT 0.06

**ALLOY LIMITS**

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

**Aluminum Remainder****CERTIFICATION**

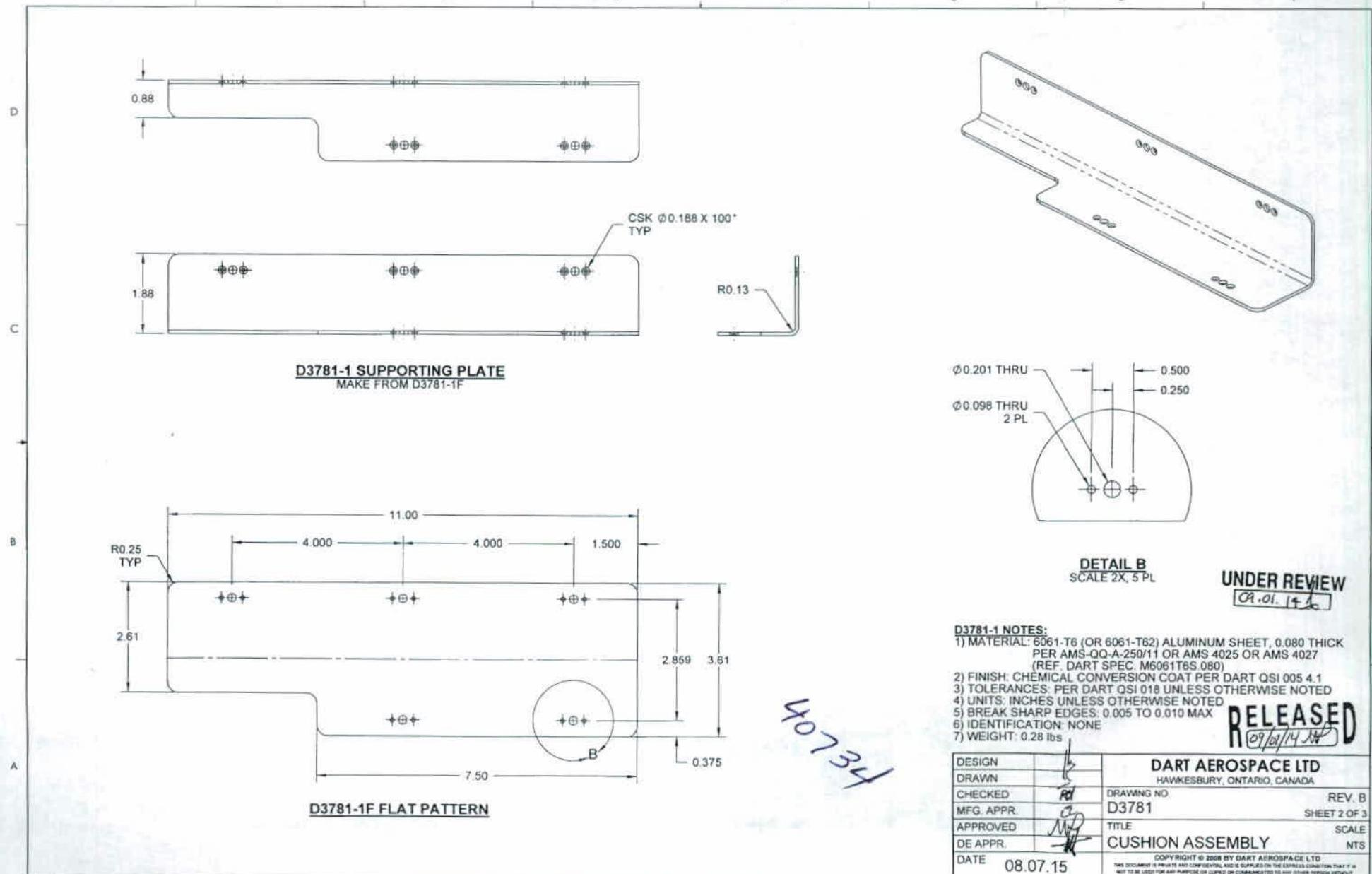
KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTON HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Page 1 of 1



8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

